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D5634-041

Job Sheet 199961



Part No: D5634-041

Job Qty: 1 pcs

POSITIVE RECALL

Part Name: Float Skidtube Assembly

EFFECTIVE 19/09/19 AUTH SAO



RELEASED DATE 19-10-03

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

55
9-89

Due Date: 9/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5634 REV:A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS IPP Rev:B A13 19.01.31 drawing
revision DP Verify DD IPP Rev:C 19.03.11 as per dwg A14 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	1 pcs	9/19/19		0.00	2.17	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		mgc
							Skidtubes - 4		TF
							Skidtubes - 5		BB
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	1 pcs	9/19/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		DAS
							QC 5 - 9		SEP 17 2019 68
							QC 5 - 50		9-89
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
115	QC 10	1 pcs	9/19/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		DAS
							QC 10 - 43		24 9-89

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				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
120 Handfinish - 1-1 Chemical-B4B	1 pcs	9/19/19	0.00 0.25	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130 QC 7	1 pcs	9/19/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
QC 7 - 68					
				Plex 9/5/19 10:12 AM Dart.lajeunesse.marie	

SEP 18 7/19

BE

					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
140 Skidtubes - 2 - B4B	1 pcs	9/19/19	0.00 0.25	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		MLG TF
				Skidtubes - 5 - B4B		
				Skidtubes - 6 - B4B		
				Skidtubes - 7 - B4B		
150 QC 5	1 pcs	9/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
160 Skidtubes - Bend - 2 - B4B	1 pcs	9/19/19	0.50 0.33	Skidtubes - Bend - B4B		MLG TF
170 QC 5	1 pcs	9/19/19	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		BE / KIN
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		
				QC 5 - 49		
				QC 5 - 51		
				QC 5 - 58		
				QC 5 - 68		
				QC 5 - 9		
				QC 5 - 50		
				QC 5 - 30		
				QC 5 - 40		
				QC 5 - 61		
				QC 5 - 81		
180 Skidtubes - 4 - B4B	1 pcs	9/19/19	0.00 2.00	Skidtubes - 1 - B4B		
				Skidtubes - 2 - B4B		
				Skidtubes - 3 - B4B		
				Skidtubes - 4 - B4B		
				Skidtubes - 5 - B4B		

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				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
195 QC 5	1 pcs	9/19/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
200 Handfinish - 1-2- Chemical-B4B	1 pcs	9/19/19	0.00 0.25	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
210 Spray Paint - 2 - B4B	1 pcs	9/19/19	0.00 0.50	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
220 QC 14	1 pcs	9/19/19	0.00 0.00	QC 14 - 15	

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					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
230	Handfinish - 4-2-Assembly-B4B	1 pcs	9/19/19	0.00 0.50	Handfinish - 4 - 1 - B4B	2019-10-2
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
240	QC 5	1 pcs	9/19/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
250	Packaging 3-1 - Stock - B4B	1 pcs	9/19/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
270 QC 21 - FG	1 pcs	9/19/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Remove fwd indexing ridge as per dwg D5634. Descriptions: Notch FWD skid thru back wall only as per section E-E. Prepare for welding 2- Weld fwd cap as per dwg D5634 and QSI004 AR Aluminum Rod Batch: 139011 3- Cut AFT end of tube at 144.0" as per dwg D5634 and deburr end. 4-Drill Aft cap pilot hole using DT8025. 5-Cleco DT8025 in position and install pilot hole drill Jig DT10533. Drill 3/16" pilot holes as per Dwg D5634-041 6-Remove inner indexing ridge on aft end of skidtube as per Dwg D5634 scribe batch # 7-Open aft end cap holes to Ø0.208" as per Dwg D5634. C'sink holes as per dwg. Deburr aft end. 8-Open cross bolt spacer holes as per DWG section C-C AND B-B and deburr as per QSI 018. 9- C'sink crossbolt spacers holes for welding only on section B-B as per dwg

110 - QC5- Inspect part completeness to step on W/O
 115 - QC10- Inspect visual per QSI004- ground welds
 120 - (Chemical Conversion Coat per QSI005 4.1)
 130 - QC7-Inspect Chemical Conversion Coat
 140 - 1-Bond D5636-041 web in place as per QSI 015. Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: Sep 18, 19 10:30pm Finish Date: Sep 18, 19 10:30pm
 150 - QC5- Inspect part completeness to step on W/O
 160 - 1-Bend AFT end of tube using bend prog. D5634 AFT as per dwg D5634. Install drop pins in crossbolt spacer holes to maintain web position.
 170 - QC5- Inspect part completeness to step on W/O
 180 - 1- Weld D3275-1 Spacers as per dwg Aluminum rod Batch: 138989 2- Grind weld flush as per dwg
 3- Insert D4720-1 Spacer. Swage as per section B-B QSI 002. Trim and grind flush per QSI 002
 195 - QC5- Inspect part completeness to step on W/O
 200 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch
 210 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: 5200209 PAINT GLOSS
 BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: 520649
 220 - QC14- Inspect Spray Paint
 230 - 1-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. 2- Wing Walk tube as per dwg.
 Batch: 5209362
 240 - QC5- Inspect part completeness to step on W/O
 250 - Identify as per dwg & Stock Location:
 270 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5633-1	CAP	1 pcs (1 ea)	100-Skidtubes - 1	5212256
D5634-041BENT	Float Skidtube Assembly, Bent	1 pcs (1 ea)	100-Skidtubes - 1	5212365
D5636-041	Float Web Assembly	1 pcs (1 ea)	140-Skidtubes - 2 - B4B	5213214
D3275-1	Cross Bolt Spacer	7 pcs (7 ea)	180-Skidtubes - 4 - B4B	5199330
D4720-1	Spacer	24 23 pcs (23 ea)	180-Skidtubes - 4 - B4B	5214318
D2646	Aft Cap	1 pcs (1 ea)	230-Handfinish - 4-2-Assembly-B4B	5215381
MS24693-C272	Screw	2 Ea (2 ea)	230-Handfinish - 4-2-Assembly-B4B	F17137

Job Allocations

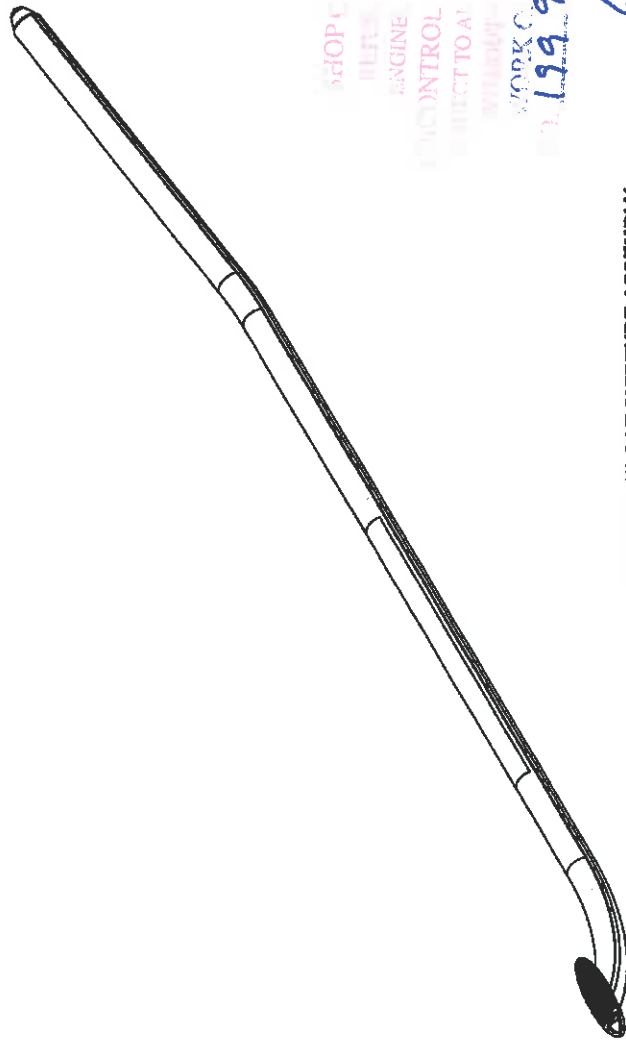
Operation	Component Part	Required	Inventory	Allocated
100-Skidtubes - 1	D5633-1	1	0	0
	D5634-041BENT	1	1	0
140-Skidtubes - 2 - B4B	D5636-041	1	0	0
180-Skidtubes - 4 - B4B	D3275-1	7	134	0
	D4720-1	23	20	0
230-Handfinish - 4-2-Assembly-B4B	D2646	1	62	0
	MS24693-C272	2	915	0

Part Specifications

Specifications could not be found.

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QTY	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2846	AFT CAP
7	D3276-1	SPACER
23	D4720-1	SPACER
1	D6633-1	TOW STEP
1	D6634-1	FLOAT SKIDTUBE
1	D6636-041	FLOAT WEB ASSEMBLY
2	M324693-C272	SCREW, CSK 100"



D5634-041 FLOAT SKIDTUBE ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.5 (FLOAT SKIDTUBE PRIMER)
PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 019.18 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 8.4 ON INNER TUBE SURFACE AT AFT END.
- 7) WEIGHT: 21.03 lb
- 8) SEAL MATING SURFACES WITH SIKAFLEX 241/291 OR PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSTALL FASTENERS W/ET WITH SIKAFLEX 241/291 OR PROSEAL P/S 880/1422 OR MIL-S-8802 CLASS B2 SEALANT
- 10) INSTALL FASTENERS W/ET WITH SIKAFLEX 241/291 ADHESIVE PER DART QSI 015.
LOCATE AS SHOWN. ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION
DANGER TO PERSONS ON BENDS:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A
HEIGHT OF 5' ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT
GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION
IN DIAMETER OF 0.180" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) WELDING PER QSI 004
GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION
IN DIAMETER OF 0.180" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 12) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FIT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
- 13) SLOT FOR D6633-1 TOW STEP THRU BACK WALL ONLY.
- 14) SLOT FOR D6633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED

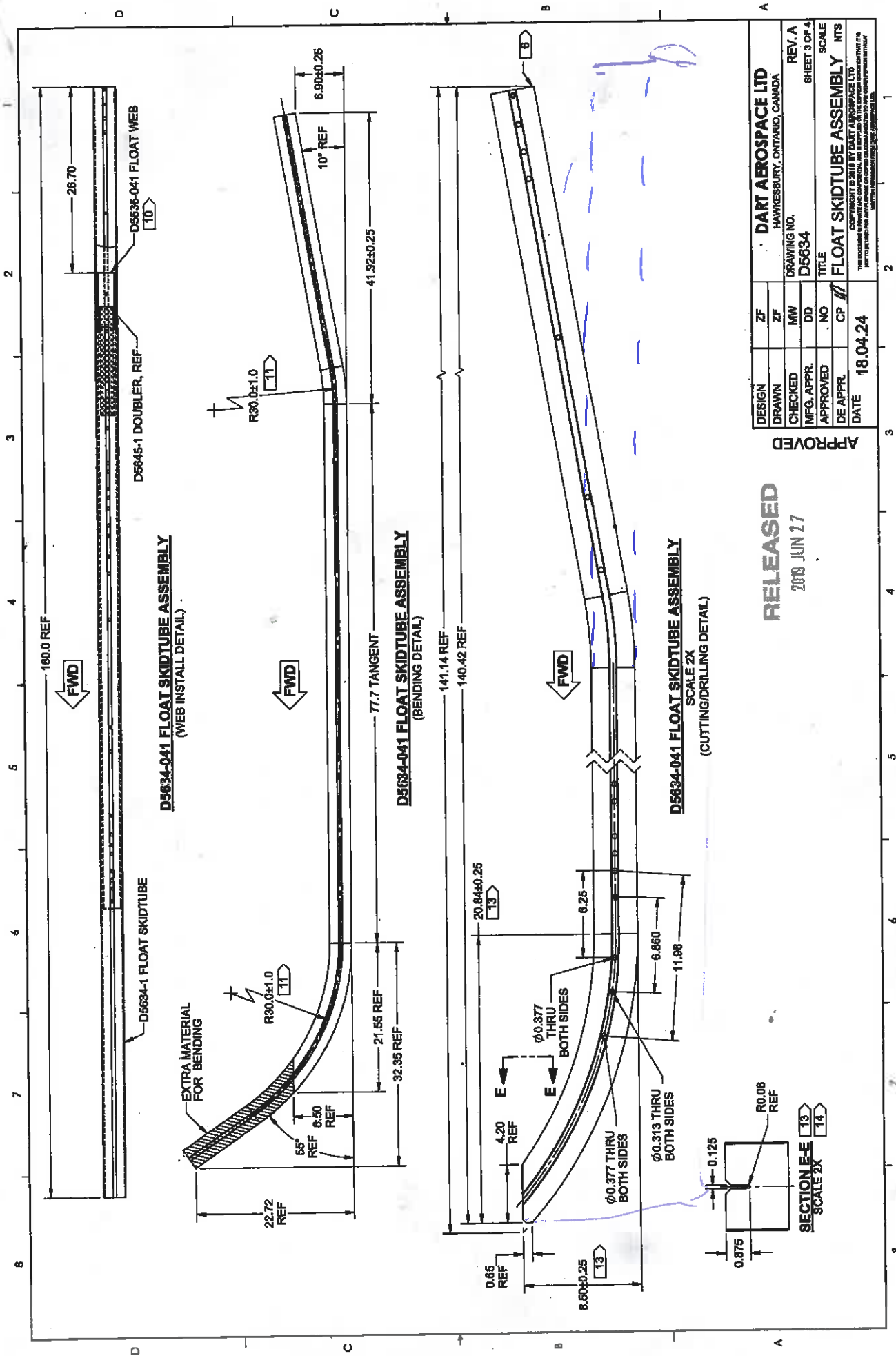
2013 JUN 27
E440 P1-746

APPROVED

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
DE APPR.					
DATE	18.04.24				

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D5634
REV. A	SHEET 1 OF 4
SCALE	SCALE
FLOAT SKIDTUBE ASSEMBLY	
N/A	

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ Machining ☐ ☐ ☐ Large Fab ☐ ☐ ☐		Cross tube ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Finishing ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐		Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ Fit/Function ☐ ☐ ☐							
				Pressure/Forced ☐ ☐ ☐ Bending ☐ ☐ ☐ Crushing ☐ ☐ ☐ Cracks ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ Mislabeled ☐ ☐ ☐							
				Power Loss/Surge ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ Weld ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐							
				Positioned Wrong ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ Drawing ☐ ☐ ☐ Finish ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ Misread ☐ ☐ ☐							
				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____							